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TITLE: PULSE OUTPUT CONTROL METHOD, AND CONSUMABLE ELECTRODE TYPE PULSE ARC **WELDING** EQUIPMENT

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ABSTRACT:

PROBLEM TO BE SOLVED: To suppress the generation of the **spatter** by repeatedly supplying the peak current and the base current in a pulse manner between a **welding** wire and a **welding** base material, setting the pulse period of the current using at least one of a **welding** output electrode or the set **welding voltage** to regularly generate the short circuit for each pulse.

SOLUTION: The short circuit to be generated in every pulse when the **welding voltage** is dropped is regularly generated, and the generation of the **spatter** is suppressed by setting the pulse period so as not to change the

average of the
pulse frequency when the **welding voltage** is dropped. In setting the pulse
period, a limiter set part to set an upper limit value and a lower limit value
of the pulse period according to at least one of the wire feed, the wire
diameter or the wire material is provided in a pulse output set part 10a to
stabilize the **welding**. A pulse frequency set part 11 to operate the pulse
period can be set by the wire feed or the like. The **spatter** is suppressed by
predicting the detachment of the droplet to complete the peak period.